

Date: Monday, 8/13/2007 9:59:13 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 33874	
Estimate Number : 12680	
P.O. Number : N/A	Part Number : D3594041
This Issue : 8/13/2007 S.O. No. : N/A	Drawing Number : D3594 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 33550	Material : N/A
Written By : <u>J. Menard</u>	Due Date : 8/20/2007 Qty: 30 Um: Each
Checked & Approved By : <u>J. Menard</u>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0578 sf(s)/Unit Total : 1.7325 sf(s)

6061-T6 .080 Sheet

Batch: M102723

IB 07-08-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: A

Prog Rev: A

IB 07-08-14

30

2-Deburr if necessary

JAD 07/03/16 30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-08-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EN 07/08/21 (x30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS [PER dwg d3594

MF 07-08-21 (30)

Date: Monday, 8/13/2007 9:59:13 AM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33874

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (430)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25 07-08-25

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-08-27

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Anchor nuts

Batch: m104214

MF 07-08-27

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

Batch: m1021

MF 07-08-27

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D3594

MF 07-08-27

(30)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28

(30) counter

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/28 (30)

Date: Monday, 8/13/2007 9:59:13 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 33874

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

PD 07/08/28

Job Completion



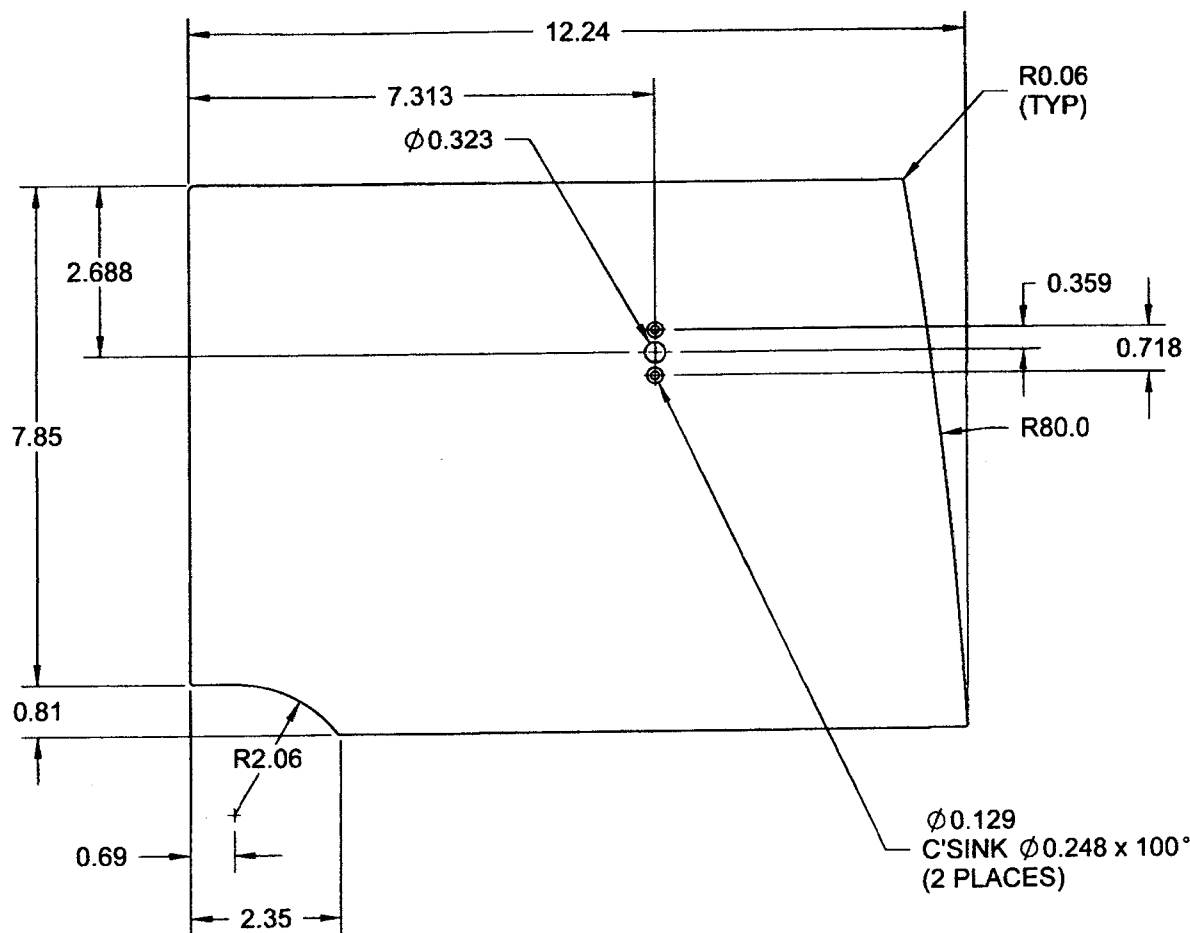
u 07-08-28

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

RELEASED
07.07.11 13

Per 60011001



D3594-3 FLOOR DOUBLER
(D3594-4 OPPOSITE)

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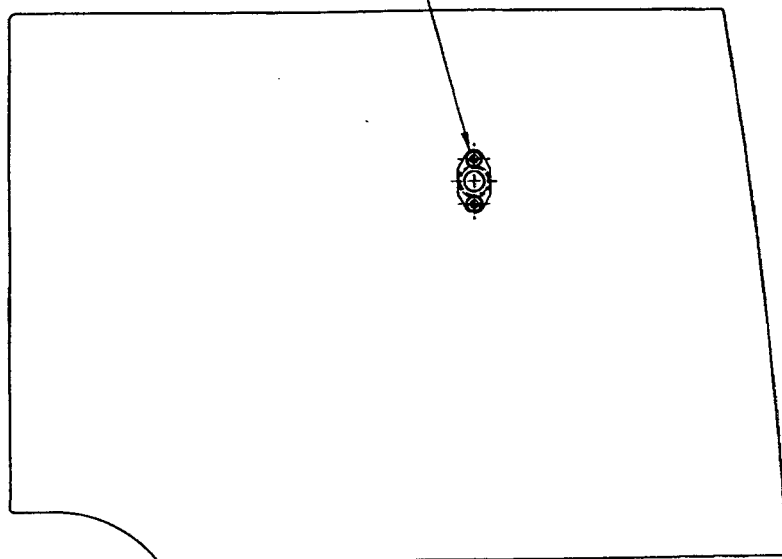


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3594	REV. A SHEET 2 OF 3
DATE 07.04.13		TITLE FLOOR DOUBLER ASSEMBLY SCALE 1:3	

RELEASED
07.07.11

Per BOM #1001

MS20426AD4-4 RIVET
(2 PLACES)



MS21069-5
ANCHOR NUT



D3594-3 FLOOR DOUBLER (D3594-043)
D3594-4 FLOOR DOUBLER (D3594-044)

D3594-043 FLOOR DOUBLER ASSEMBLY
(D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

NOTES:

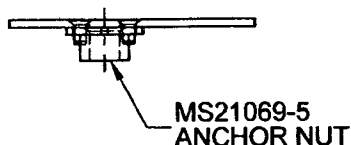
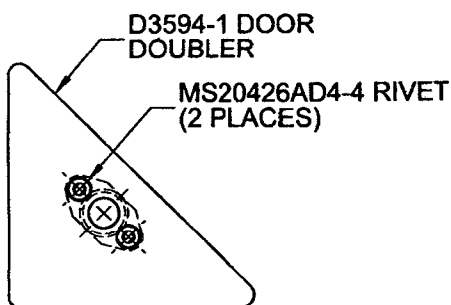
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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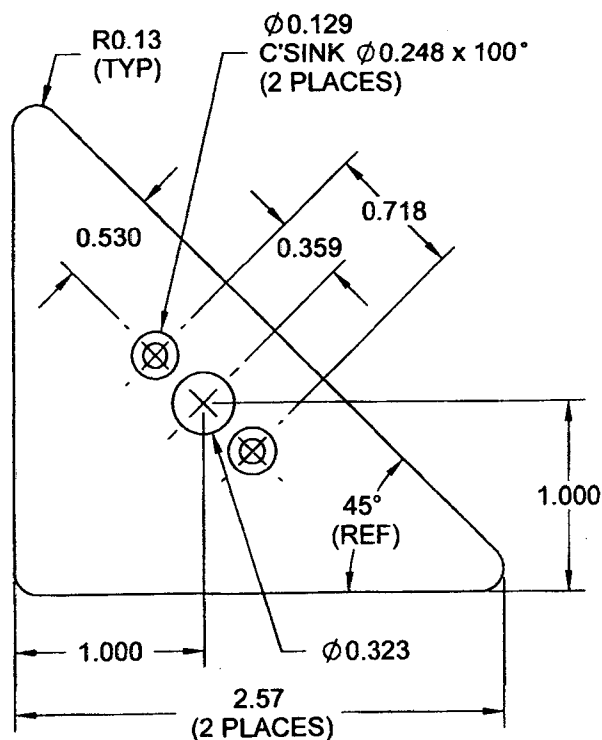
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DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 1 OF 3
DATE 07.04.13	TITLE DOUBLER		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

RELEASED
07.07.11
Per [signature]**D3594-041 DOOR DOUBLER ASSEMBLY**
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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